

## CLAIM AMENDMENTS

1           1. (original) A method for controlling the position of  
2 a mandrel (10) that is mounted in a hydraulic extrusion apparatus  
3 comprising a cylinder and a piston that form a piercing cylinder  
4 (8), of an extrusion press for producing pipes (2) that are  
5 extruded from billets (4) that are loaded into a holder (5) mounted  
6 upstream from the extrusion die (3) and pierced by means of the  
7 mandrel (10), characterized in that the piercing cylinder (8) is  
8 directly driven by pumps (11) that are adjusted to a defined  
9 pumping volume as a function of the extrusion speed and that a  
10 further pumping volume is added to the previously computed pump  
11 conveying volume, a control valve (16) acting upon the front ring  
12 compartment (12) of the piercing cylinder (8) being connected to a  
13 sump (17) for the purpose of controlling the position of the  
14 mandrel (10).

1           2. (original) The method according to claim 1,  
2 characterized in that the outlet pressure of the piercing cylinder  
3 (8) is adjusted to a defined pressure.

1           3. (currently amended) The method according to claim 1  
2 [[or 2]], characterized in that the pressure levels in both sides  
3 of the piercing cylinder (8) are monitored.